



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2281
Job Sheet 182554



Part No: D2281

Job Qty: 60 ea

Part Name: Jack Saddle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/28/18

Job Tracking No:

Due Date: 9/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV G IPP Rev:A Removed from 9 Digit 05-12-02 JLM IPP: rev B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea		9/14/18	0.00	0.00	Start Up Waterjet		18/08/30
100	Waterjet	60 pcs		9/14/18	0.00	3.14	Waterjet1		18/08/30 DAS
120	QC	60 pcs		9/14/18	0.00	0.00	QC8		AUG 31 2018 68
140	Brake NC	60 pcs		9/14/18	0.01	1.51	Brake NC 1		SEP 14 2018 68
150	QC	60 pcs		9/14/18	0.00	0.00	QC5		SEP 14 2018 68
160	Packaging	60 pcs		9/14/18	0.00	0.00	Packaging3		18/09/28-89
170	QC21-SA	60 Ea		9/14/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg Dwg Rev: G Prog Rev: G 2-Deburr if necessary
Descriptions: 140 - Form as per D2281 using D2281-T2
160 - LOCATION : WA001

DAS
21 SEP 27 2018
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S14GA	304SS sheet .080	7.5000 sf (.125 ea)	90-Start up Operation	8080377

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S14GA	8	98	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Jack Saddle	4.468Inches ± 0.010	4.478 4.458		
2	Jack Saddle	4.114Inches ± 0.010	4.124 4.104		
3	Jack Saddle	2.933Inches ± 0.010	2.943 2.923		
4	Jack Saddle	1.535Inches ± 0.010	1.545 1.525		
5	Jack Saddle	0.354Inches ± 0.010	0.364 0.344		
6	Jack Saddle	0.354Inches ± 0.010	0.364		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description W	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐	AGAINST DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐	Engineering Quality ☐ Other ☐																																																								
Part: D2281 Job No: 182554 Serial No/Batch: S106935 Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 06/30/18 DART AEROSPACE Container No: S106935 Dart Aerospace Ltd. 1270 Aberdeen Street Hertfordbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																																												
MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																												
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			0.344	
7	Jack Saddle	0.604Inches ± 0.010	0.614 0.594	
8	Jack Saddle	2.000Inches ± 0.010	2.010 1.990	
9	Jack Saddle	3.396Inches ± 0.010	3.406 3.386	
10	Jack Saddle	3.646Inches ± 0.010	3.656 3.636	
11	Jack Saddle	4.000Inches ± 0.010	4.010 3.990	
12	Jack Saddle	1.525Inches ± 0.010	1.535 1.515	
13	Jack Saddle	2.475Inches ± 0.010	2.485 2.465	
14	Jack Saddle	0.323Inches + 0.006 - 0.001	0.329 0.322	Diameter
15	Jack Saddle	0.080Inches ± 0.010	0.090 0.070	

Plex 8/28/18 10:11 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
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